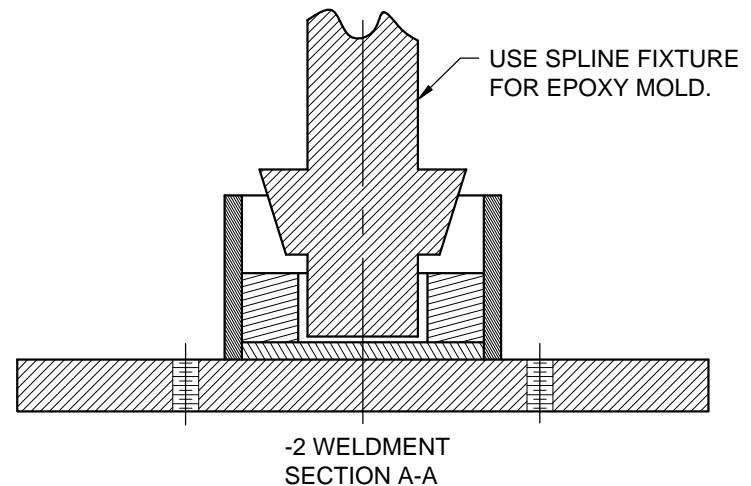
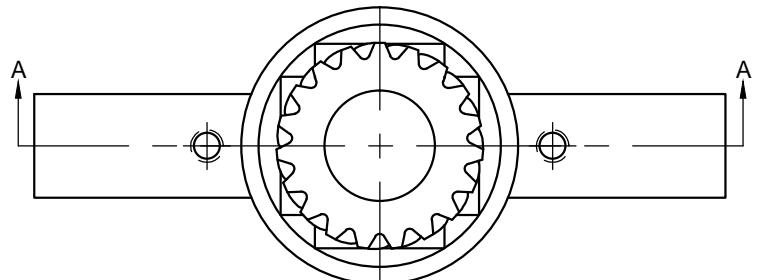


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REV		DESCRIPTION		DATE	INITIAL	APPROVED
1		IMPLEMENTED NEW FORMAT, ALSO ADDED ASSEMBLY DRAWING AND Pg. 3 EPOXY INSTRUCTIONS.		3/9/09	WP	RW
2		CHANGED PAGE NUMBERS.		5/21/09	RJC	RW

### POURING OF EPOXY INTO GEAR POTS

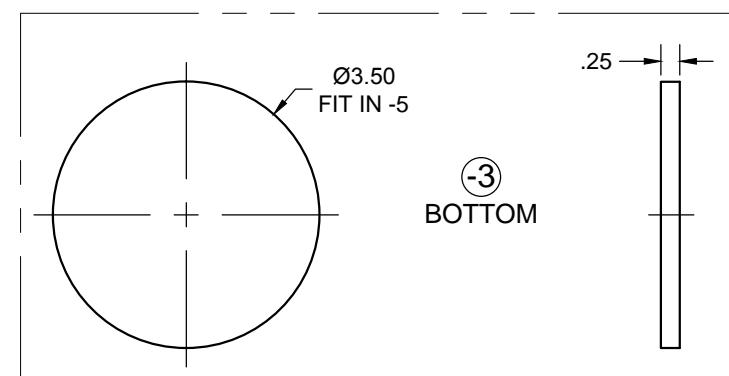
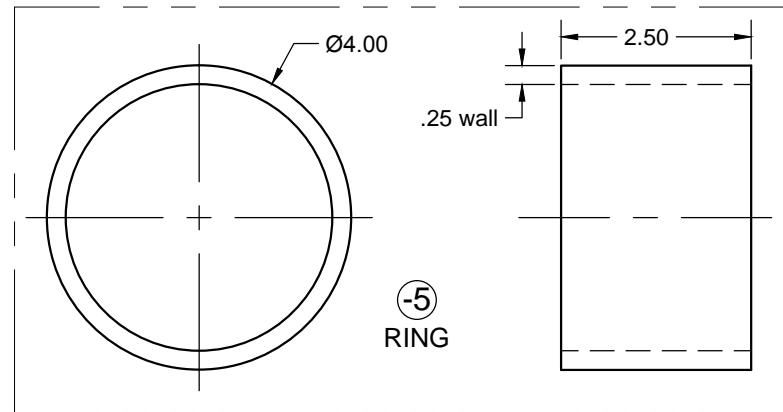
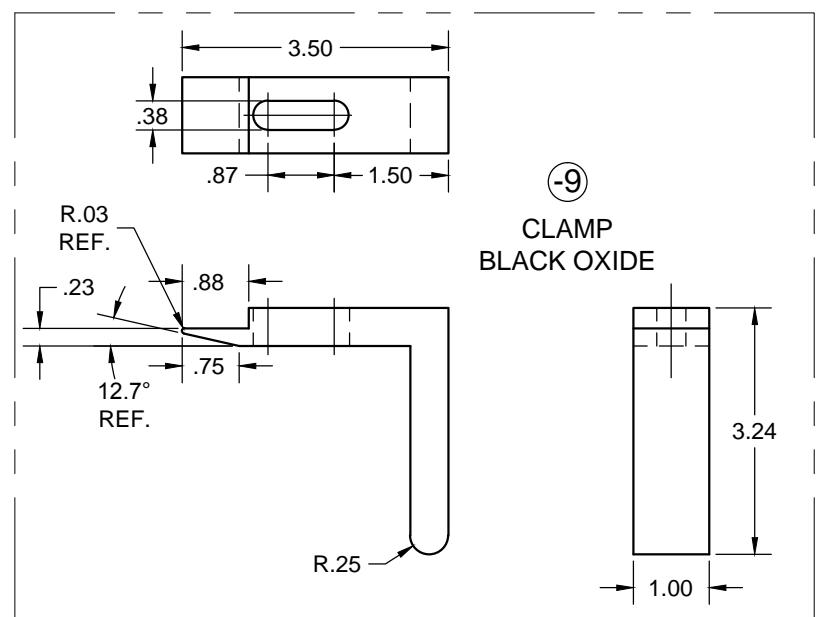
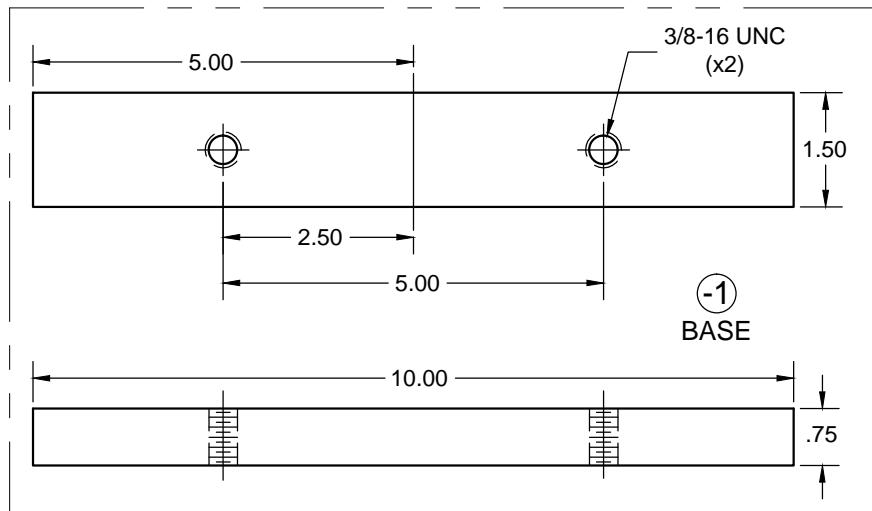
1. BE SURE THAT THE SMALL BLOCKS OF STEEL HAVE BEEN WELDED INTO THE CAVITY, THIS WILL HELP FILL THE CAVITY AND STOP THE ROTATION OF THE GEAR. BE CAREFUL TO ALLOW SPACE FOR THE EPOXY AROUND THE GEAR.
2. THOROUGHLY BEAD BLAST THE INSIDE OF THE CAVITY AND OUTSIDE OF THE HOUSING.
3. PAINT THE OUTSIDE OF THE POT ASSEMBLY WITH FLAT BLACK PAINT.
4. LEVEL THE TOP LIP OF THE CAVITY. IT SHOULD HAVE ALREADY BEEN MACHINED.
5. WET THE GEARED SPLINE WITH DEVCON BRAND RELEASE AGENT ONLY.
6. MIX FLEXANE 94 LIQUID AND THE CATALYST WITH A DRILL MOTOR AND A MIXING BLADE FOR A FULL 2 MINUTES. APPROXIMATELY A HALF CAN OF MIXED COMPOUND IS NEEDED.
7. POUR ENOUGH FLEXANE 94 INTO POT TO FILL ABOUT HALF WAY UP THE SIDE.
8. CAREFULLY PLACE THE GEARED SPLINE INTO THE MIDDLE OF THE POT.
9. CAREFULLY FILL THE POT TO THE TOP OR SLIGHTLY ABOVE, DO NOT GET MATERIAL ON TOP OF THE METAL EDGE OR DOWN THE SIDES OF THE POT.
10. USE A HEAT GUN TO BURST ALL THE BUBBLES THAT COME TO THE TOP OF THE POURED MIXTURE.
11. AFTER THE FLEXANE 94 HAS SETUP ABOUT 10 MINUTES CAREFULLY BREAK THE GEARED SPLINE LOOSE.
12. LEAVE THE GEARED SPLINE IN PLACE UNTIL THE FLEXANE HAS SET UP COMPLETELY, ABOUT 1 HOUR.
13. PREPARE EXTRA POTS AND POUR WITH EXCESS MATERIAL. DO NOT MAKE PARTIAL POURS OF FLEXANE 94 INTO POTS.



<b>RB RED BARN MACHINE</b>	
TITLE	D MODEL INPUT GEAR HOLDING FIXTURE; EPOXY MIXING INSTRUCTIONS
DWG NO.	RBD25121-30201
REV	3
UNLESS OTHERWISE SPECIFIED	DRAWN BY: PERRITT
DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	
XXX $\pm$ .005	FRACTIONS $\pm$ 1/32
XX $\pm$ .01	ANGLES $\pm$ 5°
X $\pm$ .1	
APPROVED	
HEAT TREAT	
FINISH SPEC	SEE PARTS & WELDMENT
USED ON MODEL	
1. BREAK ALL SHARP EDGES .015 x 45° PR.015 R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE	NTS
DATE	11-30-06
SHEET	3 of 3

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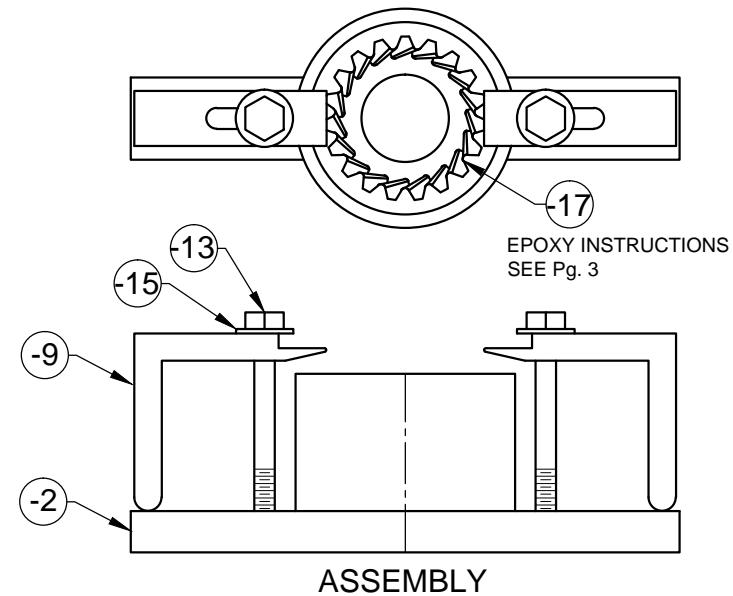
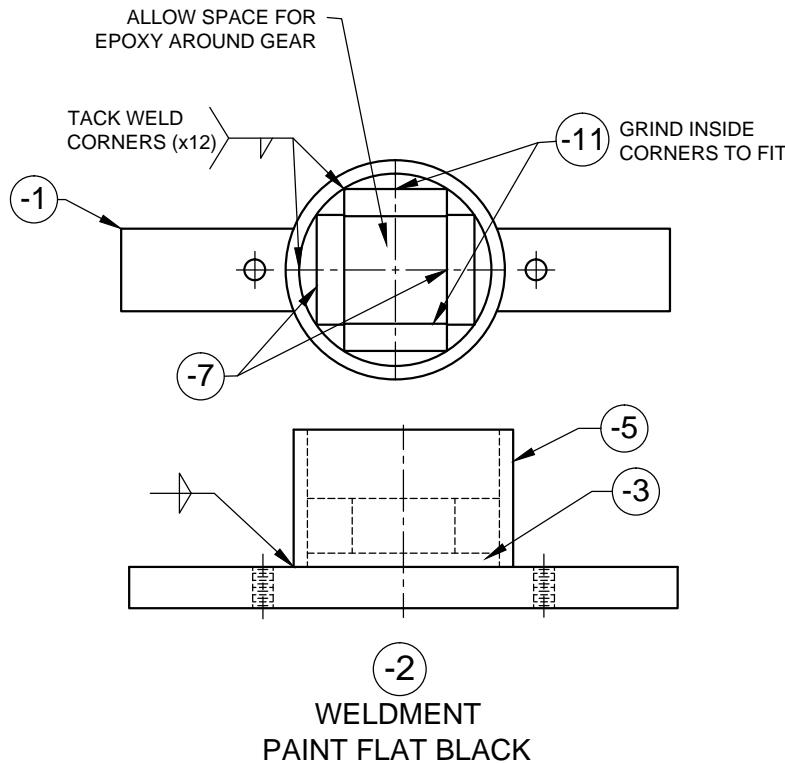
REV		DESCRIPTION		DATE	INITIAL	APPROVED
2		CHANGED PAGE NUMBERS.		5/21/09	RJC	RW
3		ADDED NOTCH CUT OUT IN -9 CLAMP TO ALLOW PART IN-BETWEEN GEAR AND BEARING. ALSO SHORTENED -5 RING FROM 2.75 TO 2.50 LENGTH TO KEEP CLAMP FROM TOUCHING.		12/10/09	WP	



 <b>RED BARN MACHINE</b>	
TITLE D MODEL INPUT GEAR HOLDING FIXTURE; PARTS	
DWG NO. RBD25121-30201-1 thru -9	
REV 3	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX $\pm$ .005      FRACTIONS $\pm$ 1/32 XX $\pm$ .01      ANGLES $\pm$ 5° X $\pm$ .1	
APPROVED HEAT TREAT FINISH SPEC SEE PARTS & WELDMENT USED ON MODEL MD 500	
SCALE	NTS
DATE	11-30-06
SHEET	2 of 3

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL APPROVED
1	IMPLEMENTED NEW FORMAT, ALSO ADDED ASSEMBLY DRAWING AND Pg. 3 EPOXY INSTRUCTIONS.	3/9/09	WP RW
2	CHANGED PAGE NUMBERS.	5/21/09	RJC RW
3	ADDED NOTCH CUT OUT IN -9 CLAMP TO ALLOW PART IN-BETWEEN GEAR AND BEARING. ALSO SHORTENED -5 RING FROM 2.75 TO 2.50 LENGTH TO KEEP CLAMP FROM TOUCHING. ALL REV 3 CHANGES PER DW	12/10/09	WP



ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.	RED BARN MACHINE	
	1		-1		BASE	1018 FLAT BAR	3/4 x 1-1/2 x 10	2	TITLE	
		X	-2	1	WELDMENT		-1 & -3 & -5 & -7 & -11	1	D MODEL INPUT GEAR HOLDING FIXTURE	
1			-3		BOTTOM	1018 RND. BAR	Ø3-1/2 x 1/4	2	DWG NO.	
1			-5		RING	DOM	Ø4 x 1/4 wall x 2-3/4	2	RBD25121-30201	
2			-7		SIDE STIFFENER	1018 FLAT BAR	1/2 x 1 x 2	2	REV 3	
			-9	2	CLAMP	ANGLE, STRUCTURAL	1/2 x 3-1/2 x 3-1/2 x 1-1/8 long	2	UNLESS OTHERWISE SPECIFIED	
2			-11		STIFFENER	1018 FLAT BAR	1/2 x 1 x 1-7/8	2	DRAWN BY: PERRITT	
		B/O	-13	2	HEX HEAD CAP SCREW	GR. 5; PLATED	3/8-16 UNC x 4	1	APPROVED	
		B/O	-15	2	FLAT WASHER	PLATED STEEL	Ø3/8	1	HEAT TREAT	
		B/O	-17	1	EPOXY	DEVCON FLAXANE 94	1/2 CAN OF MIXED COMPOUND APPLIED #15250	3	FINISH SPEC SEE PARTS & WELDMENT	
		B/O	-19	1	RELEASE AGENT	DEVCON	APPLIED #19600	3	USED ON MODEL	
ASSY -2									MD 500	
									SCALE NTS DATE 11-30-06 SHEET 1 of 3	

REVISIONS					
REV	DESCRIPTION		DATE	INITIAL	APPR
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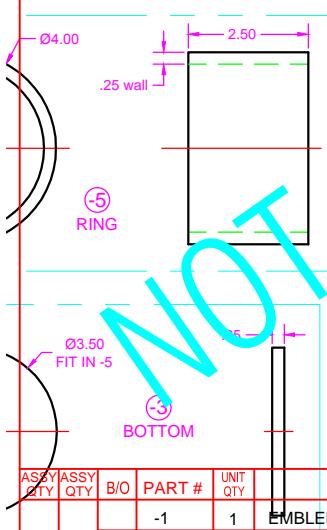
NOT APPROVED FOR PRODUCTION

REV	DESCRIPTION	REVISIONS
—	—	

25 wall

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RB RED BARN MA



ASSY #	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS
			-1	1	EMBLEM	AL. FOIL	.003 x 2 x 3-1/4
ASSY #							

 <b>RED BARN MACHINE</b>		
TITLE		
- - -		
DWG NO.		
- - -		
RE		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: <b>PERRITT</b>
TOLERANCES ON: DECIMALS $.XXX \pm .005$ FRACTIONS $\pm 1/32$ $XX \pm .01$ ANGLES $\pm 5^\circ$ $X \pm .1$		APPROVED
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES $.015 \times 45^\circ$ PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		HEAT TREAT FINISH SPEC
		USED ON MODEL
SCALE	NTS	DATE
		9-3-08
		SHEET
		1 of

A large, light blue watermark is printed diagonally across the page, reading "NOT APPROVED FOR PRODUCTION" twice. The text is in a bold, sans-serif font. The top line of text starts at the bottom-left corner and ends at the top-right corner. The bottom line of text starts at the bottom-right corner and ends at the top-left corner. The watermark is semi-transparent, allowing the underlying content to be seen through it.

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFO OR SPEC
			-1	1	EMBLEM	AL. FOIL	.003 x 2 x 3-1/4
ASSY #							

 RED BARN MACHINE	
TITLE	
DWG. NO. _____ REV. _____	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS $.XXX \pm .005$ FRACTIONS $\pm 1/32$ $XX \pm .01$ ANGLES $\pm 5^\circ$ $X \pm .1$	
DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES $015 \times 45^\circ$ PR. 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL	
SCALE	NTS
DATE	9-3-08
SHEET 1 of 1	